



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A94-1130-01
Job Sheet 193095



350 mtr

Part No: RBE703A94-1130-01

Job Qty: 5 pcs

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
95	Small Fab - 1	5 pcs	5/6/19	5/6/19	0.00	0.25	Small Fab - 1		DAS 30 9-89 6LOZ	
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
110	Small Fab - 2 - B4B	5 pcs	5/6/19	5/6/19	0.00	5.00	Small Fab - 1 - B4B		DAS 71 9-89 19-4-22	
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
120	QC 5	5 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
										DAS 30 9-89
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19-4-22

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				QC 5 - 40	
130	Packaging 3-1 - Stock - B4B	5 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	5 pcs	5/6/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS 30 9-08

APR 22 2019

DAS 21 9-08

APR 22 2019

Part Op 95 - Small Fab-3 (Small Fab) 1-ISSUE SERIAL NUMBER

Descriptions: 110 - Small Fab-3 (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-1 (Identify as per dwg & Stock Location GA 133)

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1450-E	Case	5 Ea (1 ea)	95-Small Fab - 1	
97524A032	Sealing Blind Rivet	20 Ea (4 ea)	110-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	5 Ea (1 ea)	110-Small Fab - 2 - B4B	
RBE703A94-1130-01-01	Immobilizing Clip Assembly	5 pcs (1 ea)	110-Small Fab - 2 - B4B	<u>5162244</u>
RBE703A94-1130-01-23	Deflection Clip Assembly	5 pcs (1 ea)	110-Small Fab - 2 - B4B	<u>5135250</u>
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	5 pcs (1 ea)	110-Small Fab - 2 - B4B	
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	5 pcs (1 ea)	110-Small Fab - 2 - B4B	

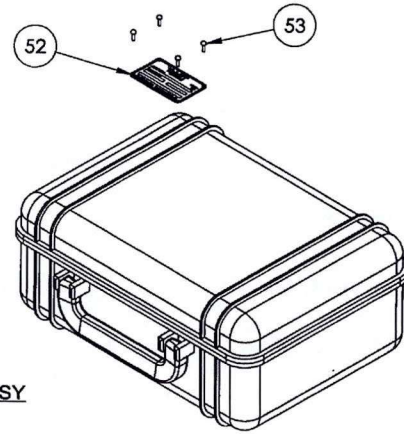
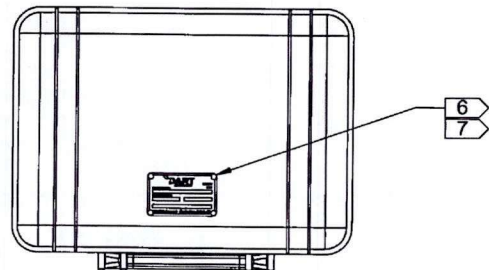
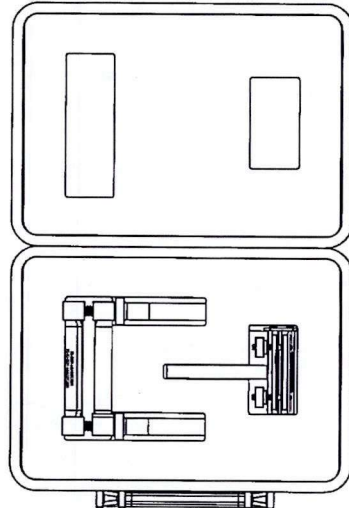
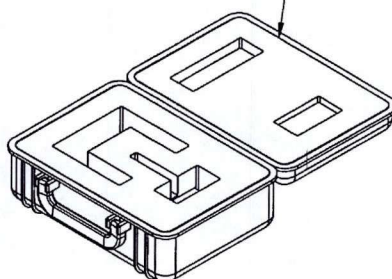
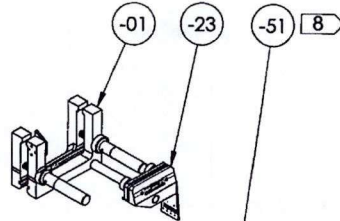
GA 133

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
95-Small Fab - 1	APP-1450-E N/A DAS 21	5	16	0	
110-Small Fab - 2 - B4B	97524A032	20	349	0	
	RB41011 N/A 9-89	5	352	0	
	RBE703A94-1130-01-01	5	5	0	
	RBE703A94-1130-01-23	5	6	0	
	RBE703A94-1130-01-47 N/A DAS 21	5	14	0	
	RBE703A94-1130-01-49 N/A 9-89	5	14	0	
Part Specifications					
Specifications could not be found.					

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ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSY	2
-23	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSY	9
-51	1	RBE703A94-1130-01-51	PACKAGING ASSY	15
52	1	RB41011	DART PLACARD	-
53	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

REV.	DESCRIPTION	DATE	BY	APPROVED
1	MOVED P/N'S -27, -29 FROM PAGE 3 TO 4. CHD ENGRAVE NOTE P/N -03. CHD HOLE DIA. P/N -28 & ADDED P.F., CHD DOWEL DIM TO METRIC ONLY. CHD P/N -27 ROLL PIN HOLE DIA. TO 4mm ONLY. ADDED P.F., CHD RADIUS DIM P/N -27. CHD DOWEL DIM TO 4mm ONLY. ADDED DEPTH. 354. CHD RADIUS DIM -29.	5/1/2009	RJC	RW
1A	-49 ADDED LID FOAM.	4/13/2011	RJC	RW
2	CHD -03 & -09 NOTE 1 PER R.W. CHD -08 DOWEL PIN HOLE FROM 0.118in. (3mm) PER G.E. -09 CHD C-DRILL FROM 0.4mm TO 0.170 PER G.E. CHD -11 0.118 HOLE FROM P.F. TO S.F. PER G.E. CHD -21 FROM 0.3mm X 20mm PER R.W. ADDED -28 DIMENSION 1.250in. (32mm) TO ENSURE -25 WILL S.F. INTO -27 PER G.E. CORRECTED -27 & -29 CHAMFER DIMENSION FROM 1.57in. TO .197 PER G.E. ADDED -51 TO BOM. CHD -41 FROM DOWEL PIN.	9/16/2011	RJC	-
2A	ADDED -09 MISSING 0.3mm HOLE P.F. -19 DIMENSION. ADDED -27 MISSING R.062 DIMENSION PER G.E.	5/21/2012	RJC	GE
2B	CHD -03 & -09 FINISH FROM CLEAR ANODIZE TO RED ANODIZE, REMOVED POWDER COATING NOTES. CHD -07 WAS #91310A558 STEEL TO #91287A165 S.S. CHD -47 WAS ROLL PIN TO DOWEL PIN.	4/17/2013	CFS	RW
3	-03, -09, -27 CHD ENGRAVE NOTE WAS RBEA94-1130-01 IS RBE703A94-1130-01. -05 CORRECTED VIEWS. CHD DIM WAS 0.315 1.25 IS 0.315 1.25 S.F., CHD DIM WAS 0.128 THRU IS 0.125/125. -07 ADDED DIM S.F. -05. CHD DIM WAS 0.125 FOR -21 IS 0.129/125 THRU. -09 CHD DIM WAS 0.118 P.F. -19 IS 0.118/0.076 (x2). -11 CHD DIM WAS 0.118 S.F. -19 (X2) IS 0.120/0.197 (X2). -28 CHD DIM WAS 0.4mm P.F. -41 IS 0.1575/1572. CHD DIM WAS 0.625 S.F. -27 IS (626) S.F. -27 -27 CHD DIM WAS 0.4mm THRU S.F. -41 IS 0.1607/1.592 S.F. -41. CHD DIM WAS 0.4mm. 354 (X2) IS 0.1575/1572 35 (X2). ADDED MISSING DIM 236. -31 CHD DIM WAS 0.157 S.F. -41 (X2) IS 0.1607/1.592. ADDED MISSING DIM (.394). -47 ADDED DIM (43) R.37.	6/24/2013	BIM	RW
4	-25 CHD DIM WAS LIMITS 0.1572 TO .1575 IS LIMITS 0.1564 TO .1570. -27 CHD DIMS WAS 0.1592 TO .1607 IS 0.1575/1590. WAS 0.1572 TO .1575 IS 0.1567/1571. -31 CHD DIM WAS LIMITS 0.1592 TO .1607 IS 0.1578 TO .1585.	4/10/2014	DPD	GE
5	SEE ECR 16-0272	12/30/2016	RJC	SM
6	SEE ECR 17-0164	6/26/2017	RJC	JAG
K	SEE ECN 17 623 - TEMPLATE UPDATE AS PER HAWKESBURY STANDARDS. -07 MATERIAL CHANGE FROM M8 SCREW TO M304R AND TOLERANCE .315/306 CHANGE TO .307 +0/- .003 AND THREAD CLASS ADDED. -05 TOLERANCE .315/316 CHANGE TO .309 +.003/-0. ASSY -61 ADDED, RIVETS AND EMPLACEMENT OF THE PLACARD ON THE PELICAN CASE ADDED	11/20/2017	VM	WM



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD (ITEM 52) BEFORE INSTALLATION ON THE PELICAN CASE (ITEM 45)
- 7) CENTER DART PLACARD (ITEM 52) IN AVAILABLE AREA OF THE PELICAN CASE'S LID (ITEM 45)
- 8) HOT GLUE TOP AND BOTTOM FOAM (ITEM -47 & -49) INTO THE PELICAN CASE (ITEM 45) AFTER DART PLACARD'S (ITEM 52) INSTALLATION
- 9) OEM P/N: E-703494-1130-01

RBE703A94-1130-01 MAIN ROTOR BLADE TRIM TAB TOOLS ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193095 HLT
19-04-08

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE MAIN ROTOR BLADE TRIM TAB TOOLS ASSY	
DWG NO. RBE703A94-1130-01	REV K
DESIGN BY: VM 9/11/2017	XXX ± .005 FRACTIONS ± 1/8"
DRAWN BY: VM 11/24/2017	XX ± .01 ANGLES ± 1°
CHECKED: WM 11/30/2017	1. DIMENSIONS ARE IN INCHES
MFG. APPR: DP 11/30/2017	UNLESS OTHERWISE SPECIFIED
APPROVED: WM 11/30/2017	2. INTERPRET DIM AND TOL. PER ASME Y14.5M-2009
DATE: 11/24/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 17	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					